

# Work Order ID 115305

March-24-14 2:43:29 PM

**\*115305\***

Page 1

Item ID: D206-817-011

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Screw-In Windshield Modification

Start Date: 3/24/14 Start Qty: 400

Required Date: 3/24/14 Req'd Qty: 400

Cust Item ID:

Customer:

Reference: ECN14-535

Approvals: Process Plan: *[Signature]*

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<b>Draw Nbr</b>	<b>Revision Nbr</b>								
DSI9659	A								
DSI9687	PA1								
IIN-D206-817	D								

100

Document Control

0.00

**\*100\***

DOCUMENT CONTROL

DC

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile & type labels per PPP D206-817-011 CHG 005

*per ECN14-535*

DAS  
31  
9-89

*1 14-04-3*

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Item ID: D206-817-011

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Item Name: Screw-In Windshield Modification

Stop **\*NS2\***

Start Date: 3/24/14 Start Qty: 4.00

**\*4\***

Cust Item ID:

Required Date: 3/24/14 Req'd Qty: 4.00

**\*4\***

Customer:

Reference: ECN14-535

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

110

Pick Kit

0.00

**\*110\***

Packaging

Memo

0.00

PULL FROM STK:

2 X D206-817-011 B110123

2 X D206-817-011 B111468

REMOVE FROM KIT AND REPLACE WITH NEW REV. PER ECN 14-535/  
DSI9687:

REMOVE FROM EACH KIT/SCRAP:

1 X D4545-041 B **B108240**

1 X D4545-042 B **B109263**

~~1 X D4541-3 B~~

~~1 X D4541-4 B~~

1 X D4541-5 B **B109414**

1 X D4541-6 B **B109436**

1 X D4541-7 B **B103181**

1 X D4541-8 B **B108195**

2 X D4542-5 B **B109423**

1 X D4594-1 B **B108028**

DAS  
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9-89

110123

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Item ID:	D206-817-011	Accept	<b>*N900040100*</b>	Setup	Start	<b>*NS1*</b>
Revision ID:					Stop	<b>*NS2*</b>
Item Name:	Screw-In Windshield Modification					
Start Date:	3/24/14	Start Qty: 4.00	<b>*4*</b>	Cust Item ID:		
Required Date:	3/24/14	Req'd Qty: 4.00	<b>*4*</b>	Customer:		
Reference:	ECN14-535					

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	<b>*NR1*</b>
	QC:	Date:	SPC (Y/N):	Date:		Stop	<b>*NR2*</b>

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
	ADD TO EACH KIT - NEW REV:								
	1 X D4541-1 B ✓								
	1 X D4541-2 B ✓								
	1 X D4542-1 B ✓								
	1 X D4542-2 B ✓								
	<del>1 X D4541-3 B</del>								
	<del>1 X D4541-4 B</del>								
	1 X D4541-5 B ✓								
	1 X D4541-6 B ✓								
	1 X D4541-7 B ✓								
	1 X D4541-8 B ✓								
	2 X D4542-5 B ✓								
	1 X D4594-1 B ✓								
	78 x MS2035AD3-4 B ✓								
	20 X MS21059L08 B ✓								
	37 X MS21059L3K B ✓								
	2 X MS21061L3K B ✓								
	20 X MS27039-0810 B ✓								
	20 X NAS1149DN832J B ✓								
120	QC4- 100% Inspect kits for completeness	0.00							
<b>*120*</b>									
QC	Memo	0.00							
Quality Control	RE-INSPECT KIT								

DAS  
31  
9-89

14-04-3

1

*[Handwritten signature]*

**Work Order ID 115305**

Thursday, April 03, 2014 1:44:22 PM

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Item ID: D206-817-011

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Screw-In Windshield Modification

Start Date: 3/24/2014 Start Qty: 4.00 **\*4\***

Cust Item ID:

Required Date: 3/24/2014 Req'd Qty: 4.00 **\*4\***

Customer:

Reference: ECN14-535

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursTool ID Tool # Plan Accept Reject Reject Insp.  
Code Qty Qty Number Stamp

130

0.00

**\*130\***

Packaging

Packaging

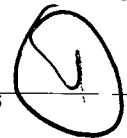
Memo

0.00

REPACKAGE PER PPP USING NEW B/N  
NEW LABELS REQ'D AT NEW CHG #Identify and pack for shipping as per PPP D206-817-  
011 Location: \_\_\_\_\_

PPP Rev: \_\_\_\_\_

APR 03 2014

DAS  
06  
9-89

140

QC21- Final Inspection - Work Order Release

0.00

**\*140\***

QC

Memo

0.00

Quality Control

MCS 14-04-03

CNF 14-4-3.

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

### FAULT CATEGORY

<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge  <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other    
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March-24-14 2:43:28 PM

**\*1 15305\***

**\*D206-817-011\***

**Required Date:** 3/24/14

**Required Qty: 4.00**

**Comments:** IPP REV:A 12.02.14 NEW ISSUE DD VERF: IPP REV:B  
12.05.09 AS PER IIN REV.C DD VERF:EC IPP REV:C 12.06.12  
ECN 12-602 DD VERF:EC IPP REV:D 13.04.23 as per IIN  
dwg rev.D DD verf:JLM IPP REV:E 13.06.26 as per  
CHG004/DSI9659 DD VERF:JFS IPP REV:F 14.03.24 AS PER DSI 9687  
DD VERF:JLM

[illegible]

# Picklist Print

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Work Order ID: 115305

\*115305\*

Parent Item: D206-817-011

\*D206-817-011\*

Parent Item Name: Screw-In Windshield Modification

D4541-6 Manufactured No

✓\*D4541-6\* DAS  
Bracket,RH 31  
9-89

Manufactured No

✓\*D4541-7\* DAS  
Bracket 31  
9-89

Manufactured No

✓\*D4541-8\* DAS  
Bracket 31  
9-89

Manufactured No

✓\*D4542-1\*  
Retainer, Inner, LH

DAS  
31  
9-89

## Location

ST532  
101314  
108232

## Loc Qty

10  
5  
5

D4542-2 Manufactured No

✓\*D4542-2\*  
Retainer, Inner, RH

DAS  
31  
9-89

## Location

ST532  
103184

## Loc Qty

5  
5

D4542-5 Manufactured No

✓\*D4542-5\* DAS  
Retainer, Inner 31  
9-89

Manufactured No

✓\*D4594-1\*  
Plate DAS  
31  
9-89

Start Date: 3/24/14

Required Date: 3/24/14

Start Qty: 4.00

Required Qty: 4.00

0.0000

4

\*\*

115293

DAS  
28  
9-89

0.0000

4

\*\*

115220

DAS  
28  
9-89

0.0000

4

\*\*

115294

DAS  
28  
9-89

10.0000

4

\*\*

115282

DAS  
28  
9-89

## Loc Code

5.0000

4

\*\*

DAS  
28  
9-89

## Loc Code

0.0000

8

\*\*

1154172x

DAS  
28  
9-89

0.0000

4

\*\*

115222

DAS  
28  
9-89

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Shop Packet Print

Page 2

# Picklist Print

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Work Order ID: 115305

\*115305\*

Parent Item: D206-817-011

\*D206-817-011\*

Parent Item Name: Screw-In Windshield Modification

MS20426AD3-4

Purchased

No

Each

8,699.000

78 X4

Start Date: 3/24/14

Required Date: 3/24/14

Start Qty: 4.00

Required Qty: 4.00

✓ \*MS20426AD3-4\*

RIVET

DAS  
31  
9-89

Location

Loc Qty

MF4

545

125578

545

ST334

3192

m127432

3192

ST509

4962

125578

4962

MS21059L08

Purchased

No

Each

994.0000

20 X4

✓ \*MS21059L08\*

Nut

DAS  
31  
9-89

Location

Loc Qty

MF4

88

125654

88

ST508

906

125654

906

MS21059L3K

Purchased

No

Each

689.0000

37 X4

✓ \*MS21059L3K\*

Nutplate

DAS  
31  
9-89

Location

Loc Qty

GA

179

m127635

179

ST316

510

m127703

510

Loc Code

\*\*

DAS  
33  
9-89

Loc Code

\*\*

DAS  
33  
9-89

Loc Code

\*\*

DAS  
33  
9-89



# Picklist Print

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Work Order ID: 115305

**\*115305\***

Parent Item: D206-817-011

**\*D206-817-011\***

Parent Item Name: Screw-In Windshield Modification

MS21061L3K

Purchased

No

Each

60.0000

Start Date: 3/24/14

Required Date: 3/24/14

Start Qty: 4.00

Required Qty: 4.00

**\*MS21061L3K\***

NUT PLATE

DAS  
31  
9-89

Location

Loc Qty

GA	4
125268	4
ST317	56
123603	56

Loc Code

\*\*

DAS  
33  
9-89

MS27039-08-10

Purchased

No

Each

2,218.000

**\*MS27039-08-10\***

Screw

DAS  
31  
9-89

Location

Loc Qty

Mezz	6
5865	6
ST307	2212
123100	2029
123265	47
m127430	136

Loc Code

\*\*

DAS  
33  
9-89

NAS1149DN832J

Purchased

No

Each

2,908.000

**\*NAS1149DN832J\***

Washer

DAS  
31  
9-89

Location

Loc Qty

MF4	944
M127255	944
ST293	1802
M127813	802
M128429	1000
st510	145
124555	145
ST510a	17
M126319	17

Loc Code

\*\*

DAS  
33  
9-89

14-04-01

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Shop Packet Print

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